

Work Order ID 151934

Friday, October 14, 2016 1:55:36 PM

151934

Page 1

Item ID: D4074-9

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blanking Plate

Start Date: 10/14/2016 Start Qty: 16.00

16

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: OCT 17 2016 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4074	D

100

0.00

100

Waterjet

Memo

0.05

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: DProg Rev: D

2-Deburr if necessary

(18)

22/10/22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.03

Quality Control

(18)

22/10/22

Picklist Print

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Page 1

Work Order ID: 151934

151934

Parent Item: D4074-9

D4074-9

Parent Item Name: Blanking Plate

Start Date: 10/14/2016

Required Date: 10/19/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 16.10.07 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No				sf	171.3240		0.269474			

M304S18GA

304/316 .050 Sheet

on 16/10/22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	65.9	
M133328	55.224	
M133587	0.7	
M134824	20.4	
M134982	20.2	
M135779	65.9	
MAT20	8.9	
M134580	8.9	

DQA: _____ Date: _____

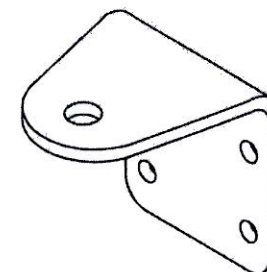
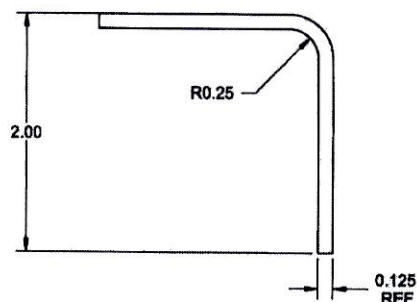
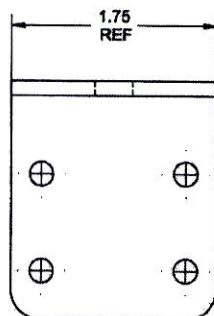
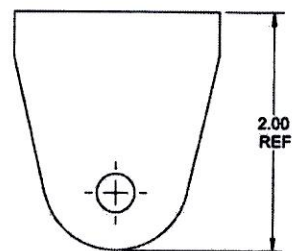
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151934 MOW
161017

D4074-1 BRACKET
(MAKE FROM D4074-1F FLAT PATTERN)

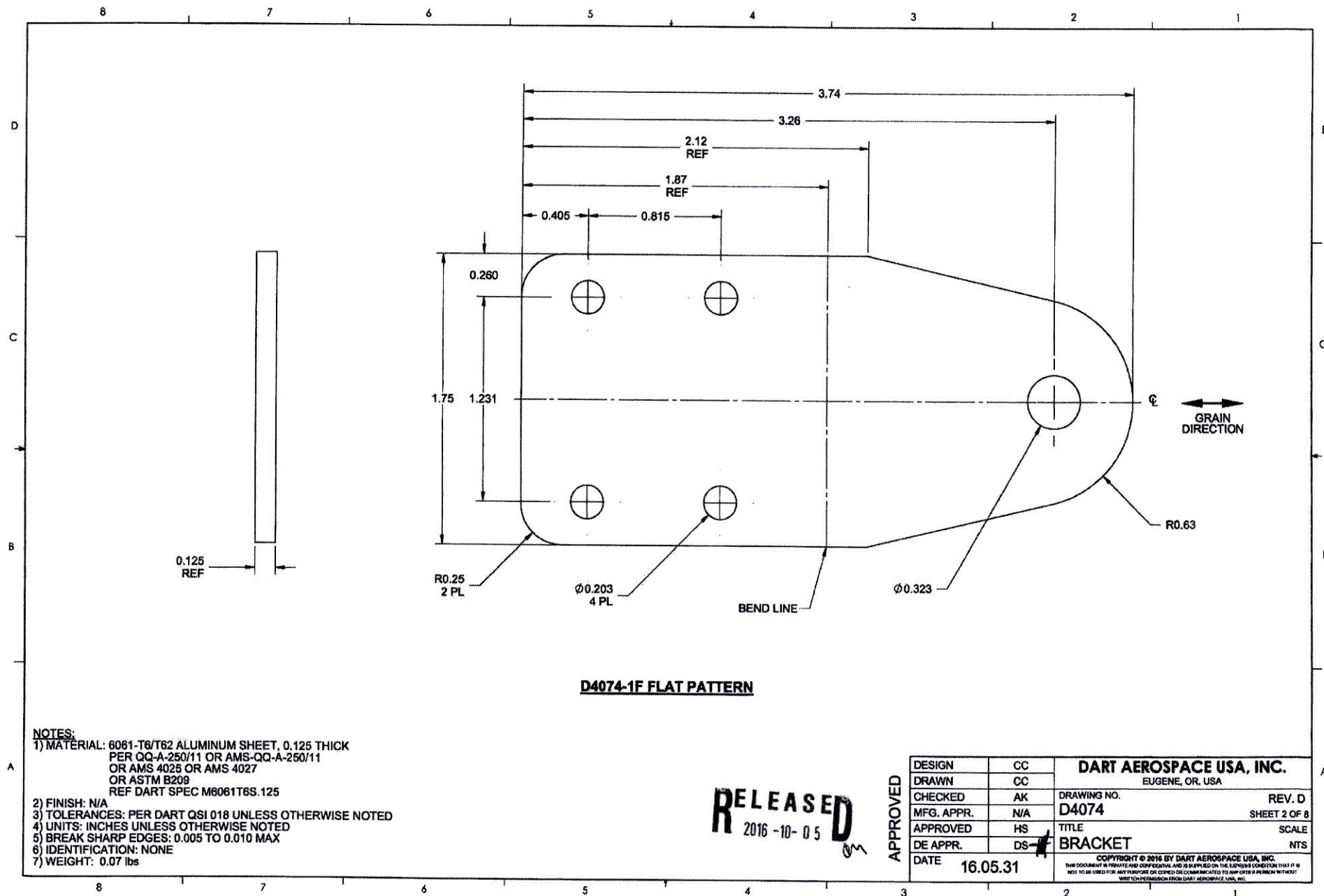
NOTES:

- 1) MATERIAL: MAKE FROM D4074-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N D4074-1 PER DART QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

RELEASED
2016-10-05
EN 16-588

D	ADDED -9 BACKING PLATE, SHEET 8. ADDED NOTE 8, SHEET 6.	CC	16.05.31
C	MODIFY -7 STRIKER PLATE, SHEET 6 AND 7	HS	11.10.12
B	Ø0.173 WAS Ø0.129 (ZN B3-4); 1.28 WAS 0.90 (ZN C4-6); 1.93 WAS 1.55 (ZN C2-7); 2.10 WAS 1.72 (ZN C1-7)	RF	11.03.07
A	NEW ISSUE	HS	10.09.16
REV	DESCRIPTION	BY	DATE
DESIGN	CC	DART AEROSPACE USA, INC. EUGENE, OR, USA DRAWING NO. D4074 TITLE BRACKET SCALE NTS COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
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CHECKED	AK		
MFG. APPR.	N/A		
APPROVED	HS		
DE APPR.	DS	REV. D SHEET 1 OF 8	
DATE	16.05.31		

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D4074-3 CHANNEL
(MAKE FROM D4074-3F FLAT PATTERN)

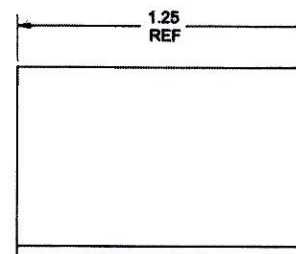
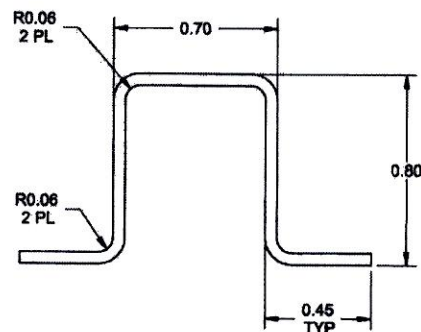
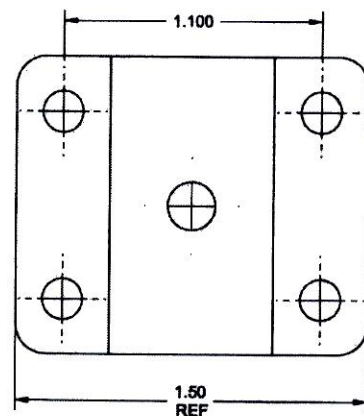
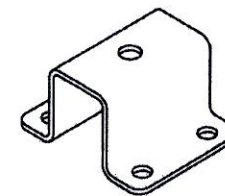
NOTES:

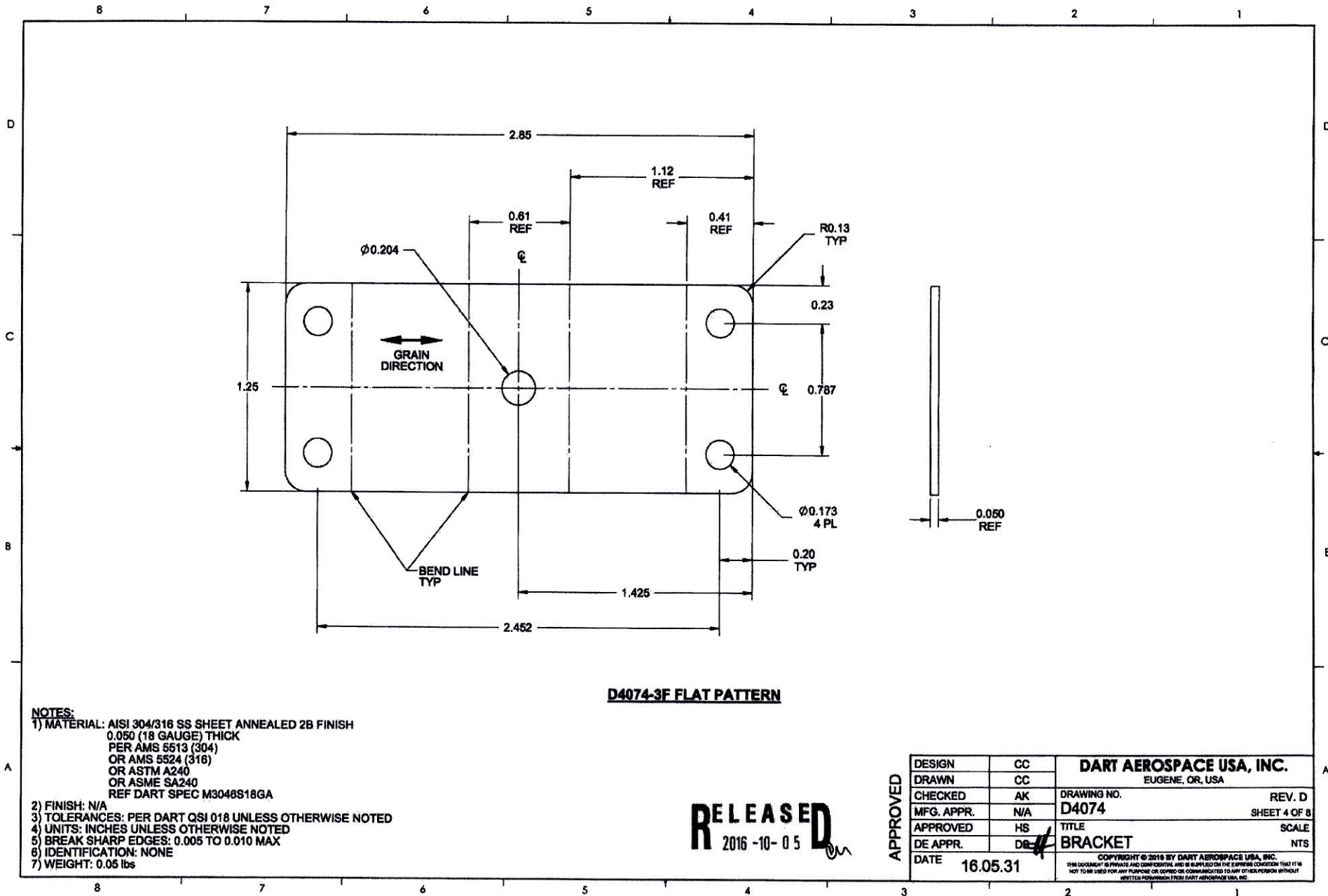
- 1) MATERIAL: MAKE FROM D4074-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N D4074-3 PER DART QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

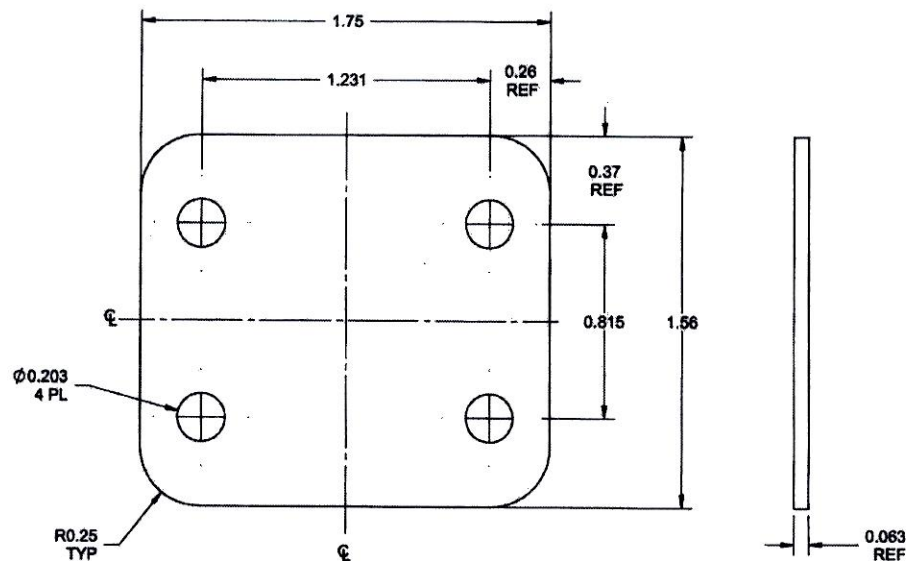
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D4074-5 BACKING PLATE

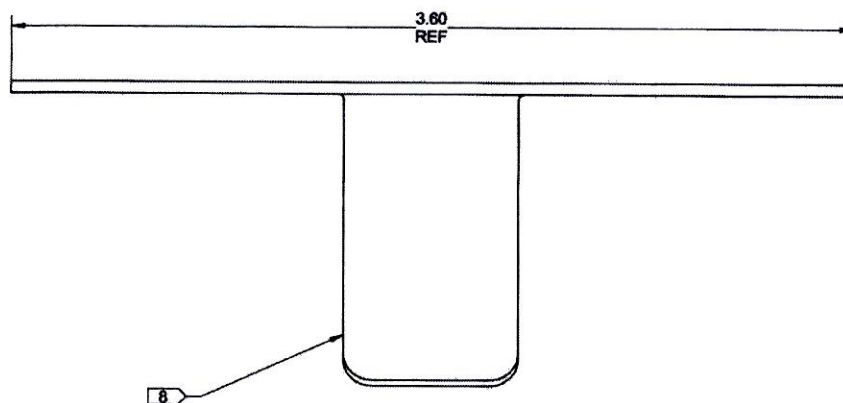
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N D4074-5 PER DART QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

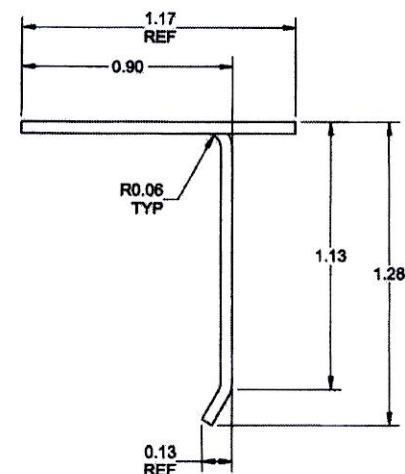
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D4074-7 STRIKER PLATE
(MAKE FROM D4074-7F FLAT PATTERN)



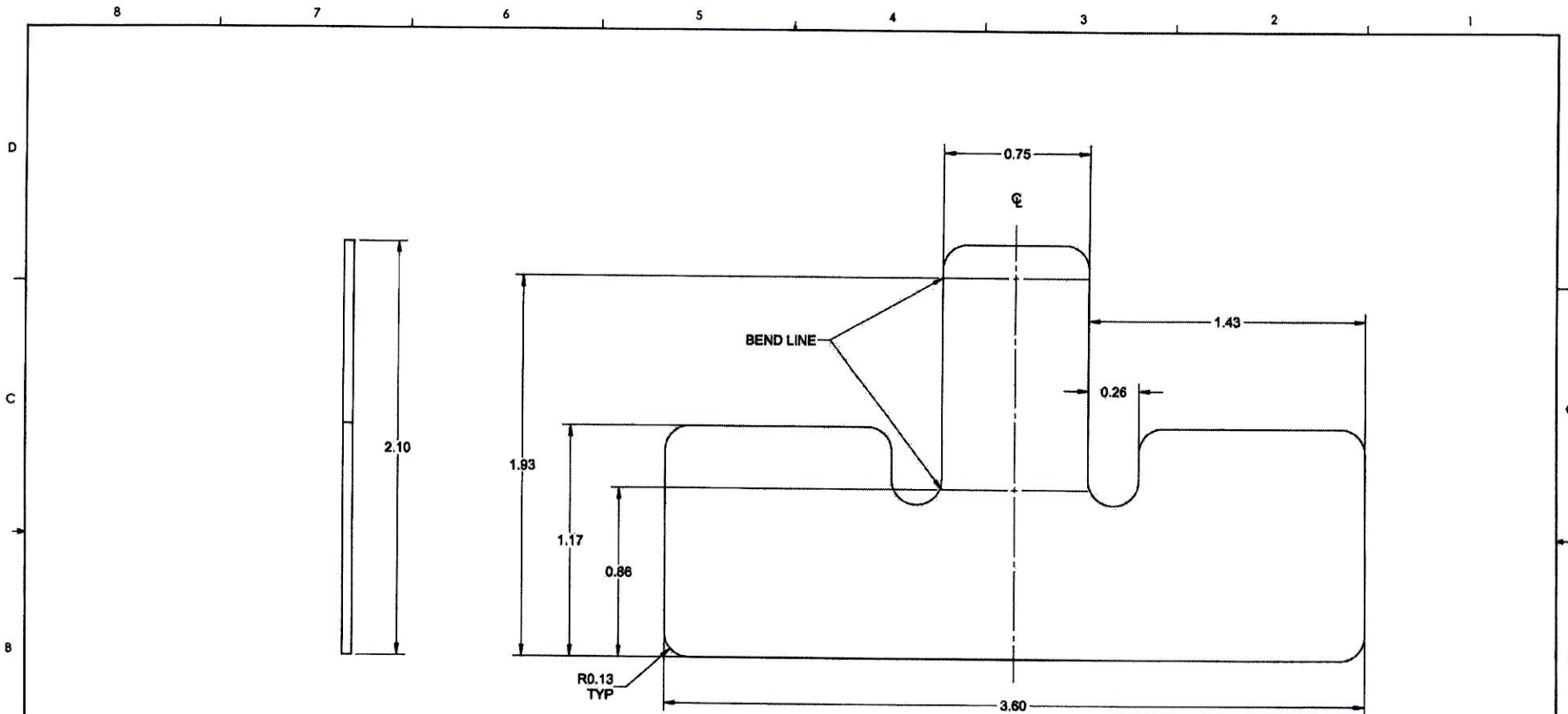
NOTES:

- 1) MATERIAL: MAKE FROM D4074-7F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N D4074-7 PER DART QSI 044 6.1
- 7) WEIGHT: 0.07 lbs
- 8) INSTALL RECTANGULAR VINYL GRIP (SUPPLIER: CAPS'N PLUGS; P/N: FE-062-740) 

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D4074-7F FLAT PATTERN

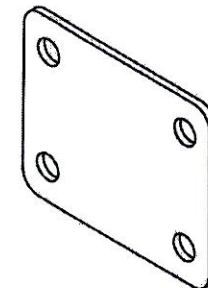
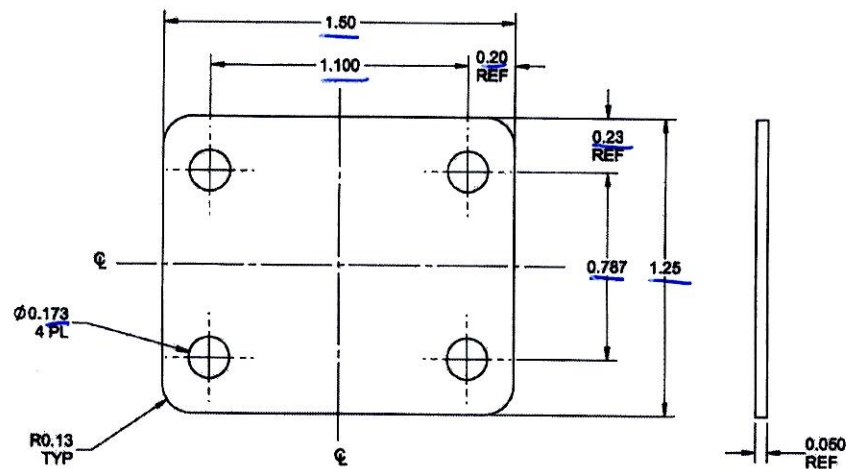
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH
0.050 (18 GAUGE) THICK
PER AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC M3046S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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D4074-9 BLANKING PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH
0.050 (18 GAUGE) THICK
PER AMS 5613 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N D4074-9 PER DART QSI 044.6.1
- 7) WEIGHT: 0.03 lbs

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